



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 175291



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Hell-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/2/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

was job # 175003 - P/W discrepancy - new job/w/o created mtl.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/31/18	0.00	0.00	Start Up Large Fab-4		<i>SL</i>
180	Large Fab	1 pcs		3/31/18	0.00	0.99	Large Fab 2		<i>DAS</i>
190	QC	1 pcs		3/31/18	0.00	0.00	QC10		<i>35 DAS</i>
200	QC	1 pcs		3/31/18	0.00	0.00	QC5		<i>9-89 38</i>
210	HandFinish	1 pcs		3/31/18	0.00	0.18	HandFinish1		<i>SA 18-04-04</i>
220	Powdercoat	1 pcs		3/31/18	0.00	0.29	Powdercoat1		<i>BR 18-7-9</i>
230	HandFinish	1 pcs		4/2/18	0.00	0.18	HandFinish3		<i>BE 18-04-10</i>
240	QC	1 pcs		4/2/18	0.00	0.00	QC3		<i>38</i>
250	Packaging	1 pcs		4/2/18	0.00	0.00	Packaging1-3		<i>5/6 APR 12 2018</i>
260	QC	1 pcs		4/2/18	0.00	0.00	QC4		<i>3-89 DAS</i>
265	DC	1 pcs		4/2/18	0.00	0.00	DC		<i>58</i>
270	Packaging	1 pcs		4/2/18	0.00	0.00	Packaging3-1		<i>9-89 DAS</i>
280	QC21-FG	1 Ea		4/2/18	0.00	0.00	QC21		<i>21 9-89 APR 17 2018 58 APR 17 2018</i>

Part Op 180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft End for Descriptions: welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod *M138673* 6-Grind End Plate flush 7-Install last rivet as per Dwg.

B38760-220 - START TIME: 3:35 OVEN TEMPERATURE: 320° FINISH TIME: 4:05.

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
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www.dartaerospace.com

Container No: S057605



Part: D350-591-311

Job No: 175291

Serial No/Batch: S057605

Revision:

Inspector:

Date: 04/03/18

wing walk A138761

Plex 4/2/18 11:55 AM Dart.Gagnon.Michelle

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-591-311	Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible	1 Ea (1 ea)	90-Start up Operation	5051557
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5046546
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	5057647
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	5041171
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-591-311	1	13	0
180-Large Fab	D3065-041	1	11	0
	D3066-1	2	72	0
	MS20600-AD4W4	16	1,071	0
250-Packaging	AN3-35A	2	238	0
	AN4-13A	8	907	0
	AN5-36A	2	212	0
	D2230-3	4	154	0
	D2618	2	402	0
	D2856-400-720	2	146	0
	D3235-1	2	232	0
	D3278-041	1	10	0
	MS21042L3	2	2,756	0
	MS21042L4	8	3,942	0
	MS21042L5	2	648	0
	NAS1149D0363J	4	2,980	0
	NAS1149D0463J	16	5,782	0
	NAS1149D0563J	4	1,962	0

Part Specifications

Specifications could not be found.

Plex 4/2/18 11:55 AM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 175003



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/26/18

Job Tracking No:

Due Date: 4/2/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/31/18	3/31/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	1 pcs	3/31/18	3/31/18	0.00	1.00	Large Fab 2		
120	QC	1 pcs	3/31/18	3/31/18	0.00	0.00	QC9		
130	QC	1 pcs	3/31/18	3/31/18	0.00	0.00	QC5		
140	HandFinish	1 pcs	3/31/18	3/31/18	0.00	0.19	HandFinish1		
150	QC	1 pcs	3/31/18	3/31/18	0.00	0.00	QC7-2		
180	Large Fab	1 pcs	3/31/18	3/31/18	0.00	1.00	Large Fab 2		
190	QC	1 pcs	3/31/18	3/31/18	0.00	0.00	QC10		
200	QC	1 pcs	3/31/18	3/31/18	0.00	0.00	QC5		
210	HandFinish	1 pcs	3/31/18	3/31/18	0.00	0.19	HandFinish1		
220	Powdercoat	1 pcs	3/31/18	3/31/18	0.00	0.30	Powdercoat1		
230	HandFinish	1 pcs	4/2/18	4/2/18	0.00	0.19	HandFinish3		
240	QC	1 pcs	4/2/18	4/2/18	0.00	0.00	QC3		
250	Packaging	1 pcs	4/2/18	4/2/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs	4/2/18	4/2/18	0.00	0.00	QC4		
265	DC	1 pcs	4/2/18	4/2/18	0.00	0.00	DC		
270	Packaging	1 pcs	4/2/18	4/2/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea	4/2/18	4/2/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-591-311	Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible	1 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	1.2000 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-591-311	1	20	0
180-Large Fab	D3065-041	1	11	0
	D3066-1	2	72	0
	MS20600-AD4W4	16	1,071	0
250-Packaging	AN3-35A	2	256	0
	AN4-13A	8	691	0
	AN5-36A	2	230	0
	D2230-3	4	190	0
	D2618	2	420	0
	D2856-400	1	48	0
	D3235-1	2	250	0
	D3278-041	1	19	0
	MS21042L3	2	3,117	0
	MS21042L4	8	3,338	0
	MS21042L5	2	692	0
	NAS1149D0363J	4	3,085	0
	NAS1149D0463J	16	3,385	0
	NAS1149D0563J	4	2,027	0

Part Specifications

Specifications could not be found.

Plex 3/26/18 10:50 AM dart.lacelle.linda



Container No: S054884



Part: D350-591-312

Job No: 175003

Serial No/Batch: S054884

Revision:

Inspector:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/26/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			

Date : _____ Step #: _____ QTY Effective : _____

Description Work Order Deviation	Disposition

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐		Out of Sequence ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐		Off-set ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐		Mislabeled ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐		Fit/Function ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐		Misaligned/off center ☐
Past Expiry Date ☐	Manufacturing Process ☐				Part Lost/Missing ☐
Misidentified ☐	Past Due ☐				Part Moved ☐
					Drawing ☐
					Finish ☐
					Misread ☐
					Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 172737



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/27/18

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/26/18	0.00	0.00	Start Up Large Fab-4		SL4
110	Large Fab	1 pcs		2/26/18	0.00	0.99	Large Fab 2		SL4
120	QC	1 pcs		2/26/18	0.00	0.00	QC9		PD 13-3-23
130	QC	1 pcs		2/26/18	0.00	0.00	QC5		PD 13-3-23
140	HandFinish	1 pcs		2/26/18	0.00	0.18	HandFinish1		
150	QC	1 pcs		2/26/18	0.00	0.00	QC7-2		
180	Large Fab	1 pcs		2/26/18	0.00	0.99	Large Fab 2		
190	QC	1 pcs		2/26/18	0.00	0.00	QC10		
200	QC	1 pcs		2/26/18	0.00	0.00	QC5		
210	HandFinish	1 pcs		2/26/18	0.00	0.18	HandFinish1		
220	Powdercoat	1 pcs		2/26/18	0.00	0.29	Powdercoat1		
230	HandFinish	1 pcs		2/27/18	0.00	0.18	HandFinish3		
240	QC	1 pcs		2/27/18	0.00	0.00	QC3		
250	Packaging	1 pcs		2/27/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		2/27/18	0.00	0.00	QC4		
265	DC	1 pcs		2/27/18	0.00	0.00	DC		
270	Packaging	1 pcs		2/27/18	0.00	0.00	Packaging3-1		
280	QC21-FG	1 Ea		2/27/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M138673 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	S047606
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	S047627
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	S051398
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	23	0
	D3219-1	2	44	0
	D3272-1	1	0	0
180-Large Fab	D3065-041	1	12	0
	D3066-1	2	50	0
	MS20600-AD4W4	16	2,001	0
250-Packaging	AN3-35A	2	162	0
	AN4-13A	8	563	0
	AN5-36A	2	188	0
	D2230-3	4	129	0
	D2618	2	276	0
	D2856-400-720	2	129	0
	D3235-1	2	54	0
	D3278-041	1	20	0
	MS21042L3	2	3,495	0
	MS21042L4	8	1,222	0
	MS21042L5	2	961	0
	NAS1149D0363J	4	3,533	0
	NAS1149D0463J	16	2,743	0
	NAS1149D0563J	4	1,454	0
Part Specifications				
Specifications could not be found.				

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

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Container No: S051557

Part: D350-591-311

Job No: 172737

Serial No/Batch: S051557

Revision:

Inspector:

Date: 03/15/18

FAULT CATEGORY

☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002475	S060524	AN3-35A	Bolt	S017089 ✓	ST348	2
002475	S060523	AN4-13A	Bolt	S045860 ✓	ST344	8
002475	S060522	AN5-36A	Bolt	S041116 ✓	ST336	2
002475	S060527	D2230-3	Mounting Lug	s051382 ✓	ST521	4
002475	S060525	D2618	Bushing	S043411 ✓	ST008	2
002475	S060526	D2856-400-720	Abrasion Strip 4" X 7.20"	S051490 ✓	ST418	2
002475	S060521	D3235-1	Mounting Lug	s049171 ✓	ST522	2
002475	S060520	D3278-041	Support Assembly	s053036 ✓	ST522	1
002475	S060519	MS21042L3	Nut	S038764 ✓	ST303	2
002475	S060518	MS21042L4	Nut	S045901 ✓	ST303	8
002475	S060517	MS21042L5	Nut	S041167 ✓	ST303	2
002475	S060516	NAS1149D0363J	Washer	S015269 ✓	ST263	4
002475	S060515	NAS1149D0463J	Washer	S045845 ✓	ST263	16
002475	S060514	NAS1149D0563J	Washer	S039036 ✓	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/12/18 2:03 PM dart.quirion.sonia

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]